

Date: Thursday, 04/12/2008 9:10:45 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
<b>Job Number</b>	: 43898	<b>Part Number</b>	: D2573
<b>Estimate Number</b>	: 10533	<b>Drawing Number</b>	: D2573 REV E
<b>P.O. Number</b>	:	<b>Project Number</b>	: N/A
<b>This Issue</b>	: 04/12/2008	<b>Drawing Revision</b>	: E
<b>Prsht Rev.</b>	: NC	<b>Material</b>	:
<b>First Issue</b>	: / /	<b>Due Date</b>	: 28/12/2008
<b>Previous Run</b>	: 43566	<b>Qty:</b>	6 Um: Each
<b>Written By</b>	:		
<b>Checked &amp; Approved By</b>	JUD 08.12.04		
<b>Comment</b>	: Est: 1 As Per RevE 06-01-27 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D6101007	Saddle Billet
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)  
 7075-T7351 8.25X7.75X2.5  
 Make from D6101-007 billet for D2573  
 Ensure that grain is along 7.75" length  
 Batch No: B42991 DIP 08/12/07

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Program Batch No. 43898 Double check by: JML

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
 4-Deburr and remove all machining marks  
 5-Tumble to remove sharp edges.

DIP 08/12/08 / J.L 08/12/10

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE  
 Machine keyway as per dwg D2573 & D2574

J.L 08/12/10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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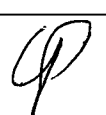



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/12/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2573 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: D Date: 08/12/16  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>43898</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.12.09	2	TOP RIDGE OF SADDLE, DIM "V" HAS A FLAT ON TOP QUADRANT. MIN DIM IS 0.217". THICKNESS AROUND HOLE UNAFFECTED.	 08.12.09 per PSI 042	ACCEPTABLE. ONLY AFFECTS 0.250" RIDGE, NOT HOLE. LANDING LOADS ACT IN OPPOSITE DIRECTION	J.L. 08/12/09	 08.12.16	 08.12.09 per PSI 042	 08.12.16

NOTE: Date & initial all entries

Date: Thursday, 04/12/2008 9:10:45 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 43898

Part Number: D2573

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.F. 08/12/15 (6)

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FZ 08/12/15 (6)

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:30  
320 OF  
3:00

M-A 08/12/15

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FZ 08/12/15 (6)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 434

JS 08/12/16 (6)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/16 JF

Job Completion



W 08.12.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43898
<b>Description:</b> Saddle, Aft Outboard		<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.002	8.002	8.002		
F	0.490	0.510		.502	.501	.505	.502		
G	0.257	0.262		0.259	0.259	0.259	.259		
H	0.375	0.380		0.378	0.378	0.378	.378		
I	0.490	0.510		0.496	.501	.498	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.562	.566	.563	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.127	0.1265	0.1265	.125		
Q	0.115	0.135		0.135	.135	.135	.135		
R	0.240	0.260		0.252	0.252	0.252	.252		
S	0.115	0.135		0.128	.123	.120	.122		
T	0.178	0.198		0.188	0.188	0.188	.188		
U	3.210	3.250		3.228	3.228	3.228	3.230		
V	0.230	0.250		0.238	.239	.217	.236		
W	0.115	0.135		0.133	.129	.123	.125		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.363	.363	.363		
AA	0.470	0.530		0.500	0.500	0.500	.500		
AB	0.615	0.635		.627	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		0.248	.245	.245	.245		
AE	1.500	1.520		1.511	1.513	1.517	1.516		
AF	0.115	0.135		0.125	.125	.125	.125		
AG	0.240	0.280		0.270	0.270	0.265	.270		
AH	0.240	0.260		0.250	.250	.246	.247		
AI	2.000	2.020		2.001	2.001	2.004	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: DTF  
Date: 08/12/08 / 08/12/09

Audited by: J.F.  
Date: 08/12/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 43898
<b>Description:</b> Saddle, Aft Outboard.		<b>Part Number:</b> D2573
<b>Inspection Dwg:</b> D2573 Rev. E		<b>Page 1 of 1</b>

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J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.565	.563				
L	1.174	1.184		1.179	1.179				
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P	0.115	0.135		.116	.125				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.250				
S	0.115	0.135		.118	.120				
T	0.178	0.198		.188	.188				
U	3.210	3.250		3.230	3.230				
V	0.230	0.250		.239	.239				
W	0.115	0.135		.116	.121				
X	0.308	0.313		.309	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.366	.369				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.627	.628				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.246	.244				
AE	1.500	1.520		1.514	1.516				
AF	0.115	0.135		.125	.125				
AG	0.240	0.280		.270	.270				
AH	0.240	0.260		.251	.248				
AI	2.000	2.020		2.001	2.003				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	JL
Date:	08/10/10

Audited by:	J.F.
Date:	08/12/15

Rev	Date	Change	Revised by	Approved
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**Dart Aerospace Ltd**

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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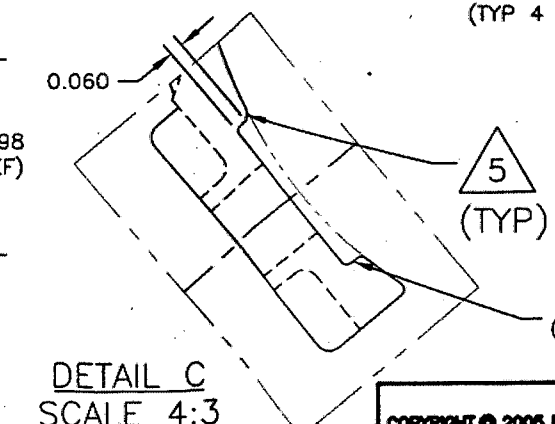
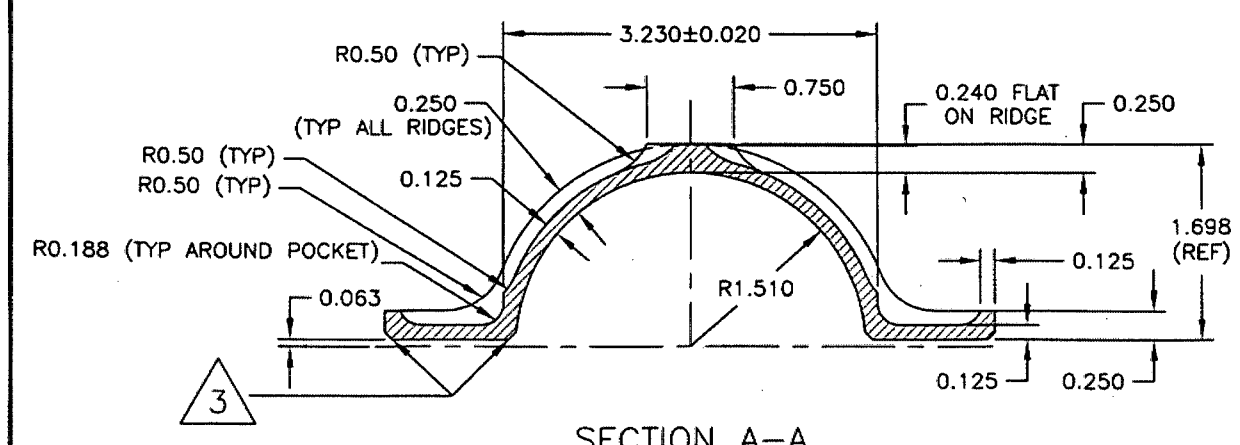
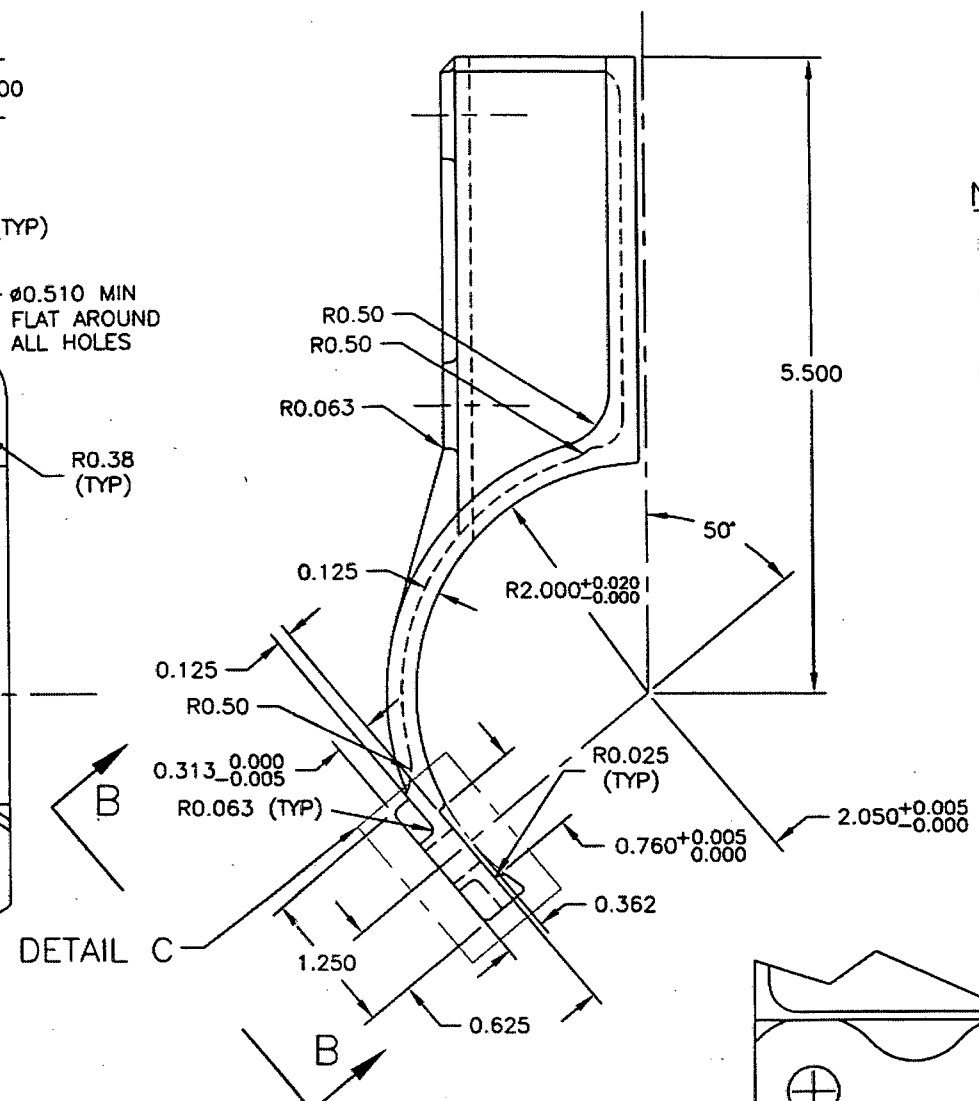
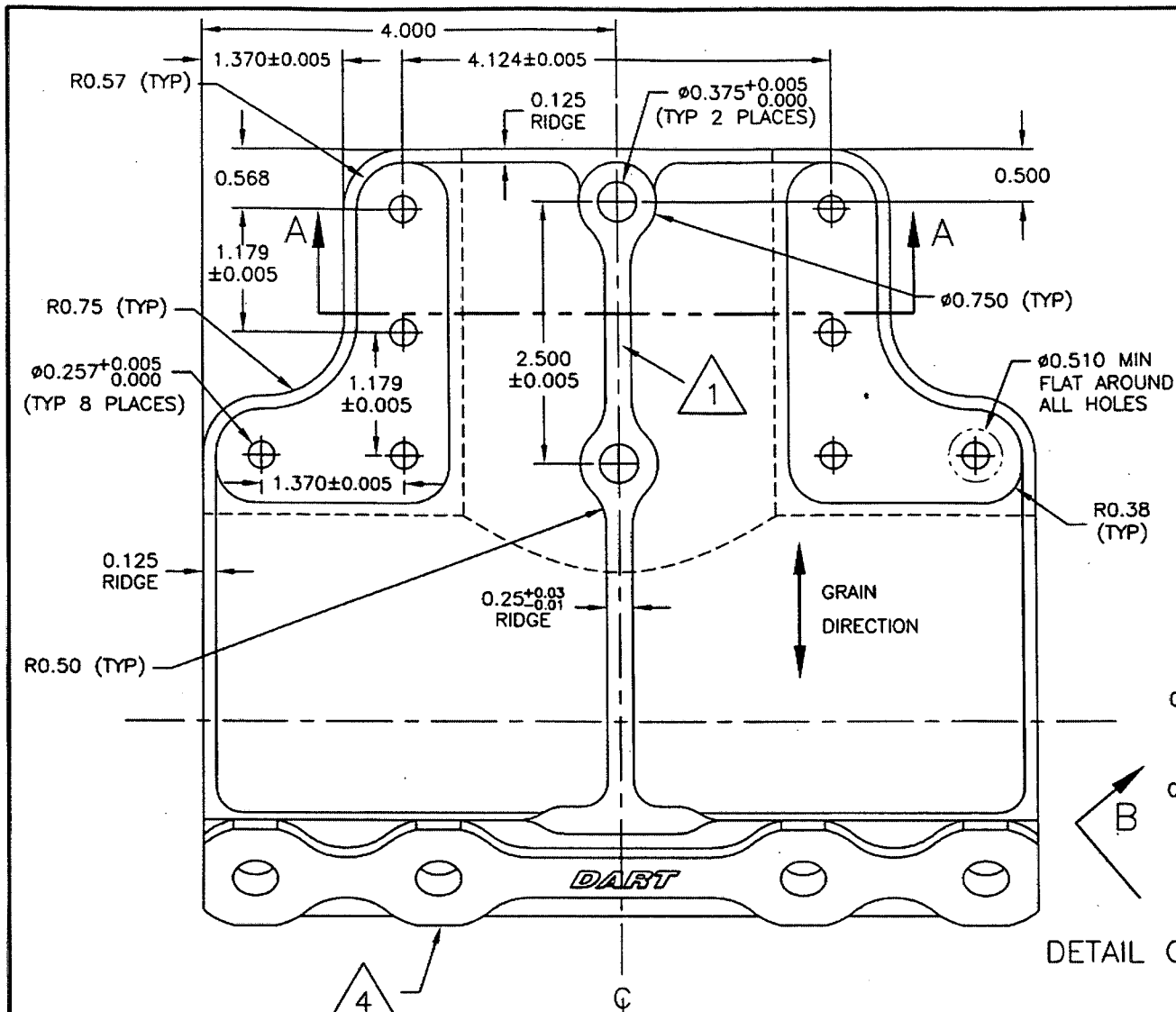
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED

05.12.06

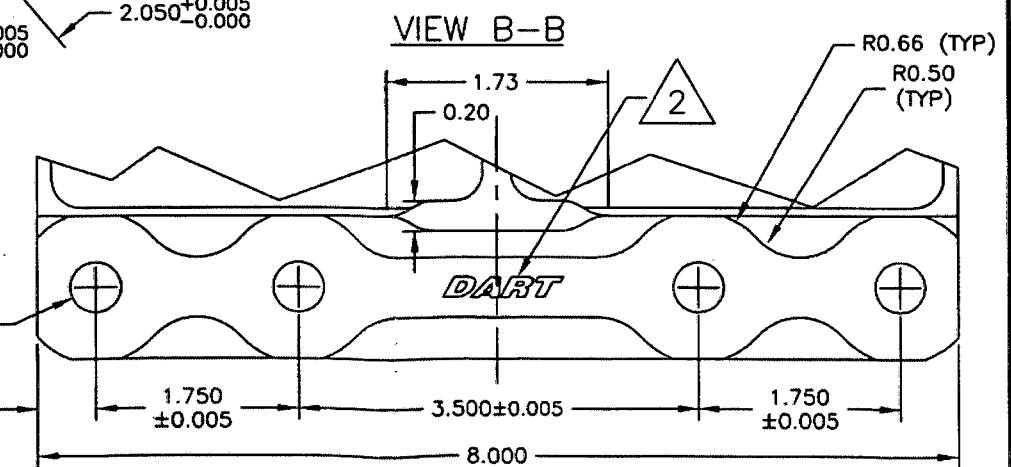


NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

VIEW B-B



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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DESIGN DS	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2573	REV. E
DATE 05.07.13		TITLE OUTER AFT SADDLE	SHEET 1 OF 1

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43818